Work Order ID 74509 Page 1 Monday, October 03, 2011 2:36:36 PM Item ID: D3535-35 Accept Setup Start **Revision ID:** Stop Item Name: Wearshoe **Start Qty: 12.00 Start Date:** 9/30/2011 **Cust Item ID: Required Date: 10/14/2011** Req'd Qty: 12.00 **Customer:** Reference: Run Start Date: Process Plan: ML J Approvals: Stop QC: SPC (Y/N): Date: Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Oty Number Stamp Otv **Revision Nbr** Draw Nbr D3535 Rev B 100 0.00 . FLOW WATER JET B1(-10-5 Waterjet 0.00 Memo □Dwg Rev: 🖒 1-Cut as per Dwg D3535 □Prog Rev: R FLOW CNC Waterjet 204,000 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 131-10-27 0.00 Memo Quality Control 0.00 120 QC8- Inspect parts - second check 8 No 178 OC 0.00 Memo Quality Control

1

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Work Order ID 74509

Monday, October 03, 2011 2:36:36 PM



Page 2

Item ID:

D3535-35

Accept



Setup Start



Revision ID:

Item Name:

Wearshoe

Start Date:

9/30/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 10/14/2011

Process Plan:

Operation

NC BRAKE

Description

Date: Date:

Tooling:

0.00

0.00

Set Up/

Run Hours

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

SPC (Y/N):

Tool ID

Plan

Code

Tool #

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

Memo

5B 11/10/30 1-Deburr if necessary □2-Form on Brake as per Dwg D3535 using Jigs

DT8261 and DT8326. □3-Identify as D3535-35.

140

QC5- Inspect part completeness to step on W/O

0.00



Quality Control

Memo

0.00

M 11 10

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



M118434

Powdercoat Powder Coating

START TIME:

_DFINISH TIME:

12x 8 M f 11/11/

Dart Aerospace	Ltd
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Picklist Print

Monday, October 03, 2011 2:36:42 PM

Work Order ID: 74509

Parent Item:

D3535-35

Parent Item Name:

Wearshoe



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	170.5795	0.8022	10.13305			
										[3	6-0-11]	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	170.5795	•
116623	0.2	4
117550	8.363	
117933	45.3442	100
118400	33.6723	•
, 118964	83	
4436		
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DART AEROSPACE LTD	Work Order:	74509
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	3.000	y		V Boz	
1.885	+/-0.010	1.884	7		V	
6.00	+/-0.030	6,00	C		T 1801	
6.75	+/-0.030	6.75	D		7	
Ø0.188	+0.005/-0.001	,193	Ъ		V	
23.250	+/-0.010	23.256	_		7	
19.750	+/-0.010	19.750	h _		T .	
17.750	+/-0.010	17,758	>		T	
14.250	+/-0.010	14,750	9		T	
9.500	+/-0.010	9,500	ما		7	
4.750	+/-0.010	4750	క		1	
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0.300	+/-0.010	-307	G		V	
0.038	+/-0.010	035	7	_	V	
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Measured by:	1jp	Audited by:	Prototype Approval:	N/A
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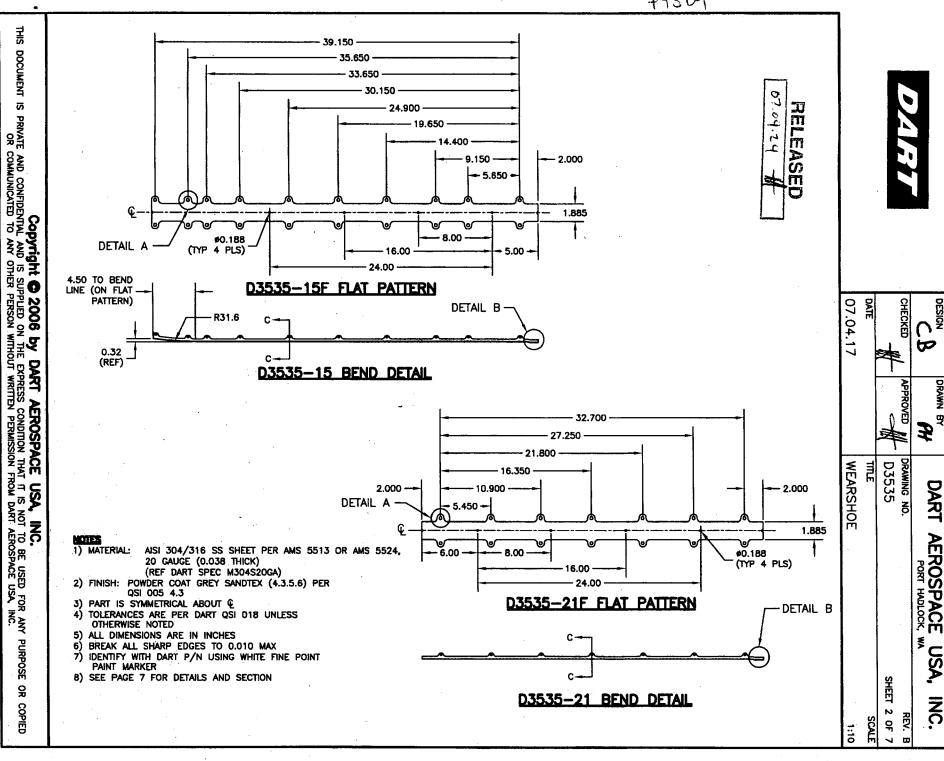
Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	 KJ/JLM	E

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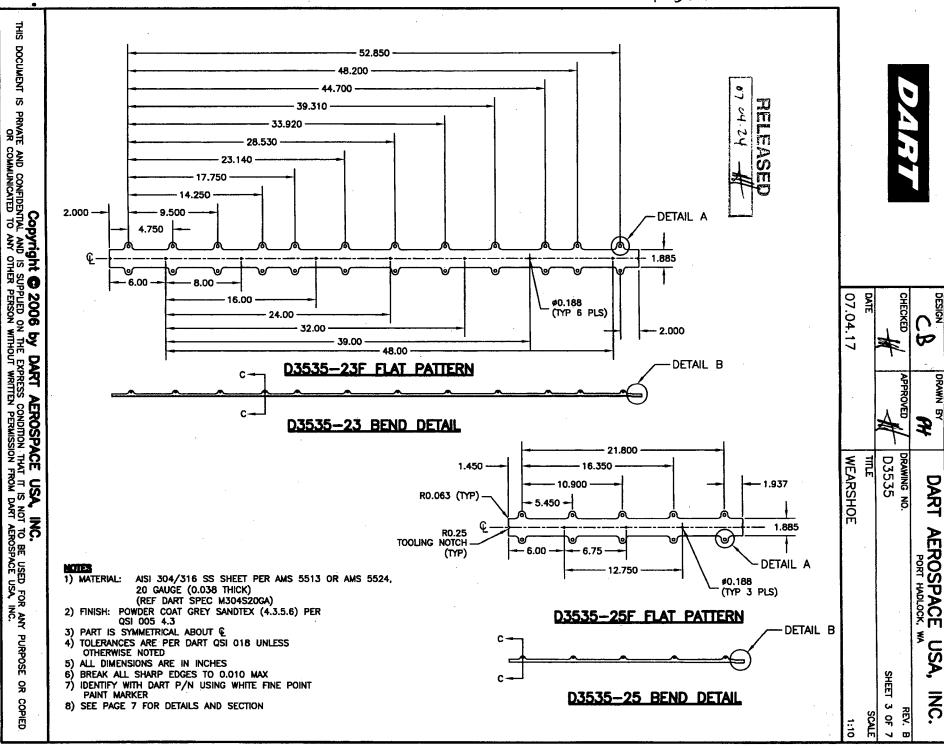
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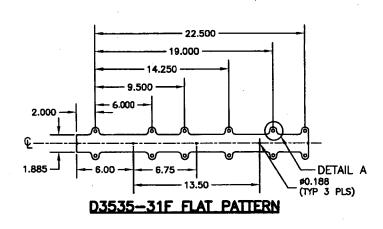
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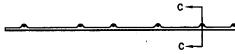
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07.04.17

WEARSHOE

1:10





D3535-31 BEND DETAIL

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	21.000							
	15.250							
	9.500							
2.000	6.000							
£								
4 707	-6.00 - 6.75 - DETAIL A							
1.885 —	13.50 __\\\\\\\\\\\\\\\\\\\\\\							
	D3535-33F FLAT PATTERN							

D3535-33 BEND DETAIL

1) MATERIAL:	AICH TO A /THE BE CHIEFT DED AND ESTE OD AND SEDA
ij maiekial:	AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
	20 GAUGE (0.038 THICK)
ř .	(DEE DART CREC MANAGORA)

- (REF DART SPEC M304S20GA)

 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

 3) PART IS SYMMETRICAL ABOUT Q

 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES

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PURPOSE

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- 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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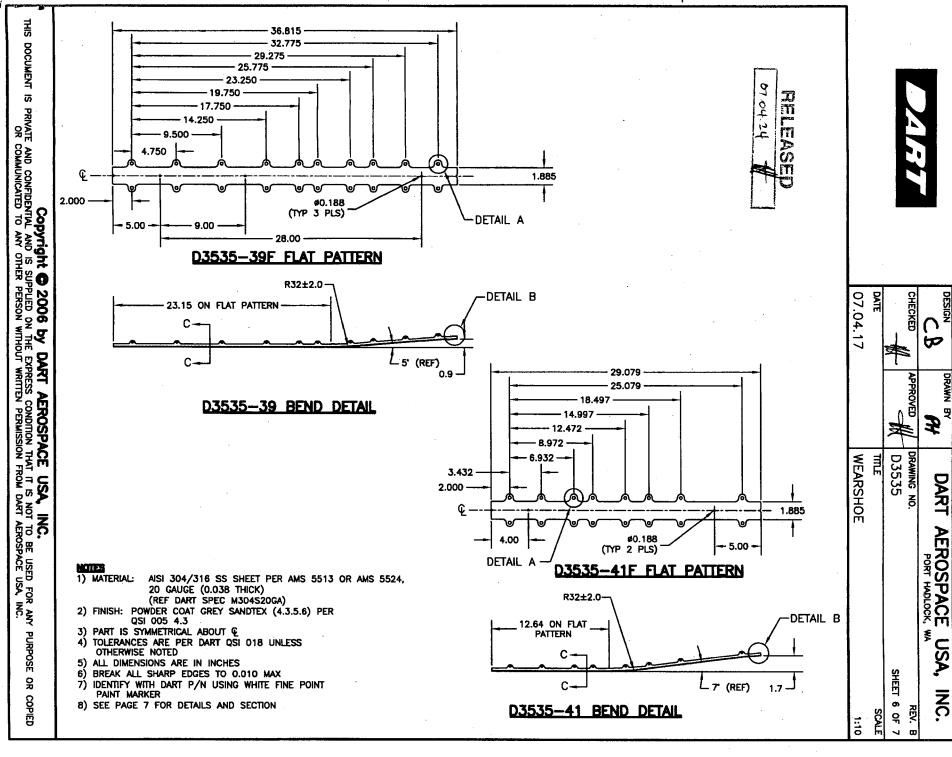
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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 9.500 4.750 2.000 #0.188 (TYP 2 PLS) 1.885 -DETAIL A D3535-35F FLAT PATTERN 07.04.17 CHECKED /D3535-35 BEND DETAIL b APPROVED 3 DRAWING NO. WEARSHOE DART 4.750 2.000 AEROSPACE PORT HADLOCK, 6.00 1.885 16.00 DETAIL A 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 90.188 (TYP 4 PLS) 1) MAIERIAL: ASI 304/316 SS SHEET PER AMS 5513
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED D3535-37F FLAT PATTERN 5) ALL DIMENSIONS ARE IN INCHES SHEET 5 OF 6) BREAK ALL SHARP EDGES TO 0.010 MAX 윶 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT NC. D3535-37 BEND DETAIL COPIED PAINT MARKER 8) SEE PAGE 7 FOR DETAILS AND SECTION 1:10

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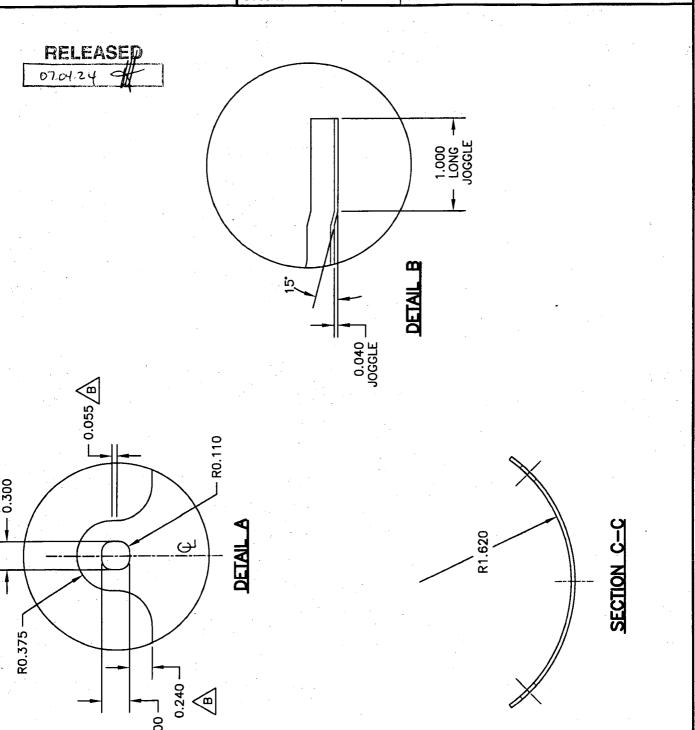
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DESIGN DRAWN BY DART AEROSPACE USA, INC. REV. B CHECKED APPROVED DRAWING NO. SHEET 7 OF 7 D3535 SCALE TITLE DATE 07.04.17 **WEARSHOE** 1:1



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